

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008763**Date Inspected:** 21-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Jia**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Trail Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S. Manjunath Math was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

Orthotropic Box Girder (OBG) Trial Assembly Areas

2AW

This Quality Assurance (QA) Inspector witnessed final tension verification for Lower Chevron for Segment 3AW between PP 20 for Cross Beam Side. Inspected 10% on a random basis and found the tension to be in general compliance. Bolt sizes used are M22x75 RC Lot No. DHGM220005 and final Torque required is 473 N-m. Manual Torque wrench was been used with Sr. No. X02-584.

CB2

This QA Inspector performed Magnetic Particle Testing (MT) of approximately 15% area previously tested by ZPMC MT personnel. This QA Inspector generated a TL-6028 MT report on this date.

1BW

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This QA Inspector observed ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) at segment hold back areas. The weld joint no. SP393-001-025/026 and 027/028 and SP329-001-033/034 and 035/036 welding was in progress. The welder is identified as 220067 and 202841. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-P-2112-FCM-1.

1AW

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) at Floor Beam to Bottom Panel against CWR B-CWR667 at PP 8.5. The weld joint no. SSD34A-PP8.5-073/074/123/81 and 079 welding was in progress. The welder is identified as 220066. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-P-2112-FCM-1.

5BW to 5CW

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) for Corner Assembly hold back areas. The weld joint no. OBW 5-1-15 welding was in progress. The welder is identified as 220067. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2233T.

5BW to 5CW

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) for Corner Assembly hold back areas. The weld joint no. OBW 5A-14 and 15 welding was in progress. The welder is identified as 2020841 and 220069. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2233T.

1BW

This Quality Assurance (QA) Inspector observed at PP 12.5 grinding of T Stiffener for Side Panel and "I" Rib for Edge Panel, Cross Beam Side was in progress for fillet welding.

1AW

This Quality Assurance (QA) Inspector observed at 1AW PP 8.5 Floor Beam to Bottom Panel CJP welding was in progress against Critical Welding Report B-CWR667 for repairing.

3AW

This Quality Assurance (QA) Inspector observed at 3AW at PP 20 Lower Chevron, Cross Beam Side shim plate of 3mm installed and bolts being renewed and new bolts with size M22x70 with Lot No. DHGM220020 being snug tightened.

1AE

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This Quality Assurance (QA) Inspector observed at 1AE to 1AAW Segment to Segment hold back fillet welded area Plate stiffener and cope holes grinding in progress.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By:	Math,Manjunath
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Quality Assurance Inspector

Reviewed By:	Carreon,Albert
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QA Reviewer
